

*Tuesday, May 24, 2011 2:19:47 PM*



**Item ID:** D2932-1

**Accept**

**Setup Start****Revision ID:**

**Item Name:** Saddle LH Out, 206

**Stop**



**Start Date:** 5/24/2011 **Start Qty:** 6.00

**Cust Item ID:**

**Required Date:** 5/24/2011      **Req'd Qty:** 6.00



**Customer:**

**Reference:**

**Approvals:**      **Process Plan:**

Date: 11-05-28 Tooling:

**Date:**

Run Start



**QC:**

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

**Stop**



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2932	Rev C								
100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1 Program part number and batch number. □1-Inspect part number and batch number are programmed correctly. □2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet □3-Machine Step No 2 of Folio and visually inspect as per									
110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet									
120		0.00							
	QC1- Inspect dimensions to dimension sheet								
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69922**

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Item ID: D2932-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 5/24/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 BL 11-7-8

170

Identify as per dwg &amp; Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

11/7/8 SP 6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11 JF  
MF 11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 24, 2011 2:19:56 PM

Page 1

Work Order ID: 69922



Parent Item: D2932-1



Parent Item Name: Saddle LH Out, 206

Start Date: 5/24/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev, (mpp 2069)□EC□  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	24.0000	1	6			
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Saddle Billet, 7075



29 11.7.6

## Location

## Loc Qty

## Loc Code

MAT040

14

68171

14

MAT45

10

68172

10

✓ x 5  
6970/ x 1

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
5

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 69922
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	5 By	6 Date
A	0.100	0.140		.133	.133	.133	.133	.133	.133
B	0.100	0.140		.135	.135	.135	.135	.135	.135
C	0.100	0.140		.130	.130	.130	.130	.130	.130
D	0.210	0.230		.220	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.238	.238	.238
N	0.100	0.140		.110	.110	.110	.110	.110	.110
O	0.540	0.560		.552	.552	.552	.552	.552	.552
P	0.490	0.510		.499	.499	.499	.499	.499	.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.493	2.493	2.493	2.493	2.493	2.493
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.130	.130	.130	.130	.130	.130
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.125	1.145		1.134	1.136	1.136	1.136	1.136	1.136
Y	1.565	1.585		1.573	1.574	1.574	1.574	1.574	1.574
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: RF
Date: 11.7.12

Audited by: CMX
Date: 11/07/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

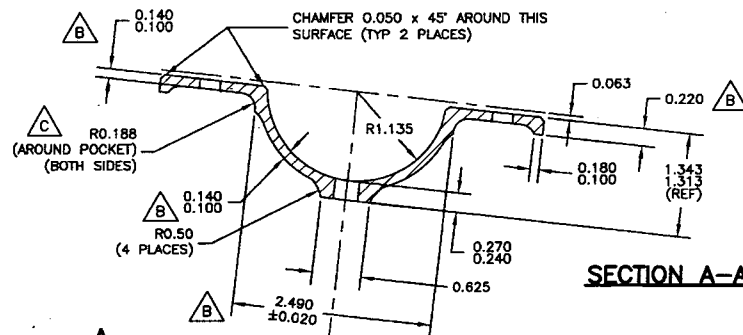
W/O:		WORK ORDER CHANGES					
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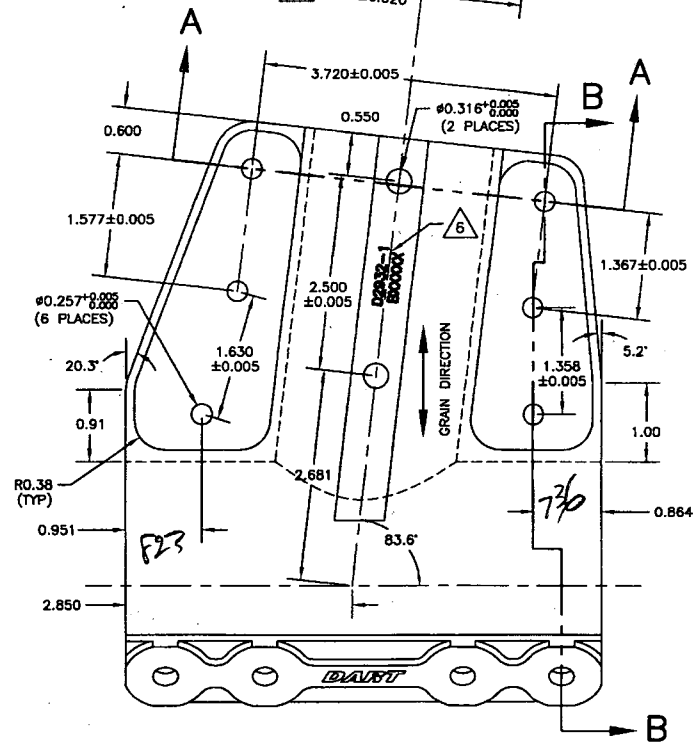
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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SECTION A-A

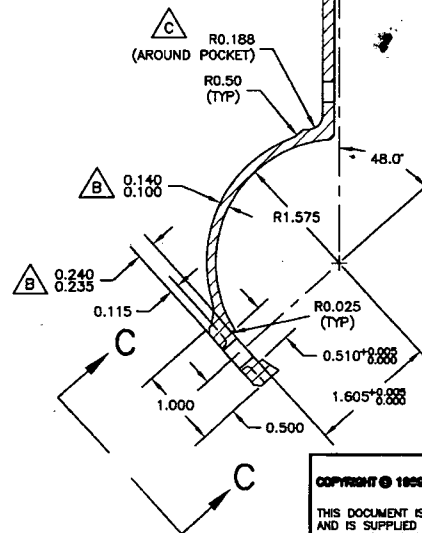


RELEASED

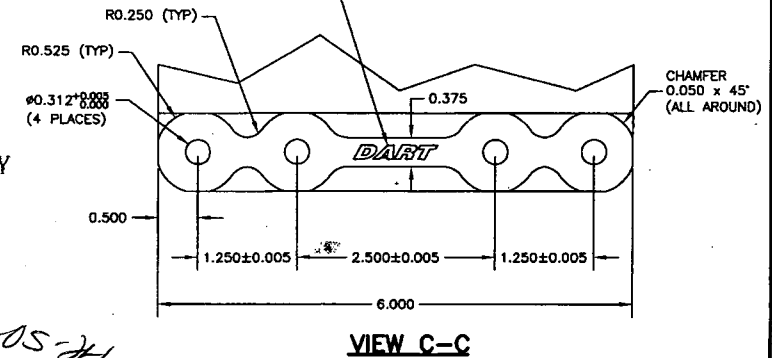
07-02-12

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 49922

SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH  
OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.

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